

Work Order ID 149177

July 20, 2016 1:41:12 PM

149177

Ship Aug 17.

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Item ID: D412-761-041 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Full Vertical Reference Door Modification (Wide Armrest)
Start Date: 7/20/2016 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 8/3/2016 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: SH Date: 7/20/16 Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D412-761	F							DAS 21 9-89	1607-27
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D412-761-041 CHG003								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.01							
Quality Control									

AUG 26 2016

① PC

AUG 26 2016

AUG 26 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

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Item ID: D412-761-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Full Vertical Reference Door Modification (Wide Armrest)

Start Date: 7/20/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 8/3/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-761-041								
	Location: _____								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.02							
Quality Control									

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AUG 2 6 2016

2m 16/08/26

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Work Order ID: 149177

149177

Parent Item: D412-761-041

D412-761-041

Parent Item Name: Full Vertical Reference Door Modification (Wide Armrest)

Start Date: 7/20/2016

Required Date: 8/3/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 09-01-13 rev.C as per dwg DD verified by:EC IPP Rev:B as per ECN10-573 DD 10.05.18 verf:EC IPP Rev:C 13.01.15 as per ECN13-511 DD Verf:JLM IPP Rev:D 16.06.21 PER IIN REV.F DD Verf:JLM IPP REV:E 16.06.24 PER CH003 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D412-761-053

Manufactured No

Each 1.0000

1

D412-761-053

Door Mounted Instrument Panel, LH

N/A SH 7/20/16 see attached email

Location

Loc Qty

Loc Code

FG020

1

116704

1

D412-761-045

Manufactured No

110

Each

0.0000

1

1

D412-761-045

Bubble Window

147757

D412-761-047

Manufactured No

110

Each

0.0000

1

1

D412-761-047

Instrument Panel

146949

D412-761-049

Manufactured No

110

Each

0.0000

1

1

D412-761-049

Armrest

148345

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JUL 29 2016

Shirley Hay

From: David Shepherd
Sent: July 06, 2016 5:10 PM
To: Linda Lacelle; Harvey Siemens; Arkam Kindeel
Cc: Shirley Hay; Marc Bellavance; Lori Morris
Subject: RE: d412-761-041

Linda,

Sorry for the slow reply. I had Arkam incorporate DSI 9681 into IIN-D412-761 Rev F, which meant adding the optional D412-761-053 kit. What I didn't notice is that he added this optional kit to the BOM for D412-761-041/-041A, which is NOT correct. The D412-761-053 kit should be removed from the BOM for D412-761-041/-041A. The customer doesn't need to receive 2 instrument panels with his door. Sorry for the confusion.

Marc,

Can you please create a PAR/NCR/CAR to request an update to IIN-D412-761 to remove the D412-761-053 kit from D412-761-041/-041A.

Regards,
David

From: Linda Lacelle
Sent: July-06-16 1:12 PM
To: David Shepherd <dshepherd@dartaero.com>; Harvey Siemens <hsiemens@dartaero.com>; Arkam Kindeel <akindeel@dartaero.com>
Cc: Shirley Hay <shay@dartaero.com>; Marc Bellavance <mbellavance@dartaero.com>; Lori Morris <lmorris@dartaero.com>
Subject: RE: d412-761-041

Any news on this one please?

From: Linda Lacelle
Sent: Tuesday, July 05, 2016 11:48 AM
To: David Shepherd <dshepherd@dartaero.com>; Harvey Siemens <hsiemens@dartaero.com>; Arkam Kindeel <akindeel@dartaero.com>
Cc: Shirley Hay <shay@dartaero.com>; Marc Bellavance <mbellavance@dartaero.com>; Lori Morris <lmorris@dartaero.com>
Subject: d412-761-041
Importance: High

HELLO ALL,
NOT SURE WHO TO ASK:

We have shipped numerous kits to Bell – D412-761-041. There was an ECN released on June 24th, and now the BOM is calling up the D412-761-053. Is this correct? We have only shipped the -045/ -047/ -049 in these kits, and if we have to add the -053, we may have Bell come back and ask for this for the other kits already received. Shirley is in the midst of issuing w/o's for the next kits, and is now unsure if the bom is correct...can anyone please clarify??

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Ship Aug 11

Page 1

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 Revision ID: Stop *NS2*
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 Start Date: 7/20/2016 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 8/3/2016 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: SH Date: 7/20/16 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D412-761	F								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D412-761-041 CHG003								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.01							
Quality Control									

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JUL 27 2016

JUL 27 2016

6.0 PARTS LIST, FULL VERTICAL REFERENCE DOOR MOD KITS

QTY -041	QTY -041A	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	QTY -141	PART NUMBER	DESCRIPTION
									D412-761-011	FULL VERTICAL REFERENCE DOOR, LH
									D412-761-011A	FULL VERTICAL REFERENCE DOOR, LH
X									D412-761-041	FULL VERTICAL REFERENCE DOOR KIT, LH
	X								D412-761-041A	FULL VERTICAL REFERENCE DOOR KIT, LH
		X	1						D412-761-043	MODIFIED LATCH MECHANISM KIT, LH
1	1		X						D412-761-045	LARGE BUBBLE WINDOW KIT, LH
1	1			X					D412-761-047	DOOR MOUNTED INSTRUMENT PANEL KIT, LH
1					X				D412-761-049	ARMREST KIT, LH
	1					X			D412-761-051	ARMREST KIT, LH
1	1						X		D412-761-053	DOOR MOUNTED INSTRUMENT PANEL KIT, LH
								X	D412-761-141	VENT KIT
		1							D3589-041	LATCH ASSEMBLY
		1							D3589-047	FORWARD GUIDE
		1							D3589-049	AFT GUIDE
		2							MS16997-24	SCREW
		2							MS21042L06	NUT
		2							NAS1149DN632J	WASHER (OR AN960JD6L)
			1						D3676-1	LARGE BUBBLE WINDOW
			1						D3678-1	PLACARD
			1						D3678-3	PLACARD
			1						D3678-5	PLACARD
			1						D3700-1	INBOARD WINDOW DOUBLER
			1						D3700-3	OUTBOARD WINDOW DOUBLER
			1						D3701-1	FLOOR DOUBLER
			1						D3702-1	FORWARD DOUBLER
			1						D3703-1	AFT DOUBLER
			1						D3703-3	AFT CORNER DOUBLER
			1						D3703-5	AFT CAP
			1						D3704-1	ESCUTCHEON
			1						D3704-3	ESCUTCHEON
			1						D3708-1	ANGLE
			1						D3708-3	ANGLE
			1						D3709-1	ANGLE
			1						D3709-3	ANGLE
			1						D3802-1-135	SEAL
			1						DT9458	CUTTING TEMPLATE
			26						AN3-7A	BOLT
			26						MS21042L3	NUT
			1						MS24694-C5	SCREW (OR MS24694-S5)
			1						MS24694-C13	SCREW (OR MS24694-S13)
			1						NAS43DD3-24	SPACER
			52						NAS1149D0363J	WASHER (OR AN960JD10)

(CONTINUED ON PAGE 12)

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Revision: F
 Date: 16.05.26